

July 29, 2016 2:05:44 PM

Page 1

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

July 29, 2016 2:05:44 PM

Page 2

Reference:

Run	Start	*NR1*
	Stop	*NR2*

0.00

0.01

QC

Memo

Quality Control

140	0.00
-----	------

Small Fab

Small Fab

Memo

Small Fab

Assemble D3674-045 as per Dwg D3674

150	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

0.01

QC

Memo

Quality Control

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 149768

July 29, 2016 2:05:44 PM

149768

Page 3

Item ID: D3674-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Roller Bracket Assembly
Start Date: 7/29/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/2/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 	0.00							AUG 02 2016
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
170									AUG 23 2016
QC	Memo	0.07							
Quality Control									

**DAS
21
9-89****AUG 22 2016**
AUG 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

July 29, 2016 2:06:01 PM

Page 1

Work Order ID: 149768

149768

Parent Item: D3674-045

D3674-045

Parent Item Name: Roller Bracket Assembly

Start Date: 7/29/2016

Required Date: 8/2/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev: A RQ Verified by: DD 16.06.24

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3137-5 *D3137-5* Washer		Manufactured	No				Each	21.0000		4		16/08/02	DAS 36 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST019			21					
					138927			1					
					147380			20					
* D3674-7 *D3674-7* Guide		Manufactured	No				Each	0.0000		4		16/08/02	DAS 36 9-89
MS24694-S100 *MS24694-S100* Flat Head Screw		Purchased	No				Each	40.0000		4		16/08/02	DAS 36 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST283			40					
					m134574			40					
M174B0.500X02.000 *M174B0 500X02 000* 17-4 SS Bar .500 x 2.00		Purchased	No			100	f	3.0660	0.375	1.578947		16/07/31	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					MAT010			3.066					
					→ m128572			3.066				1.516 ft	

DQA: _____ Date: _____



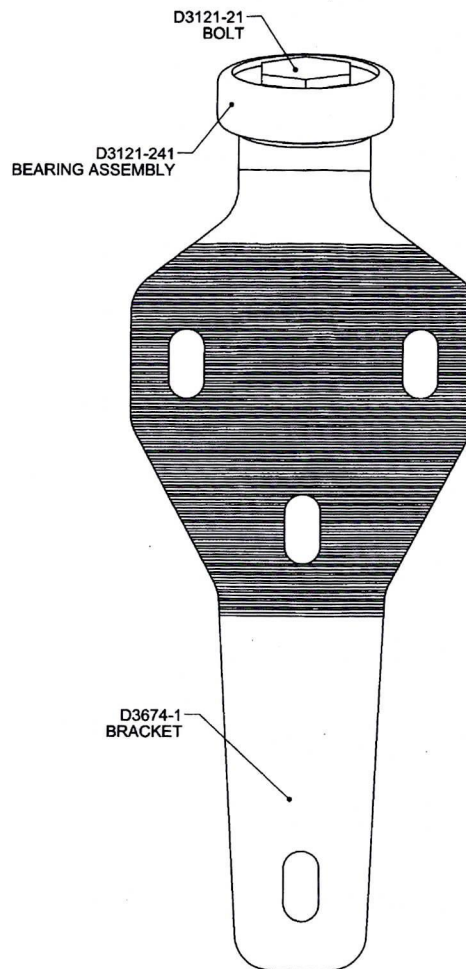
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3674-041	ROLLER BRACKET ASSEMBLY
1	1	D3674-1	BRACKET
2	1	D3121-21	BOLT
3	1	D3121-241	BEARING ASSEMBLY



NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.31 lbs
 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

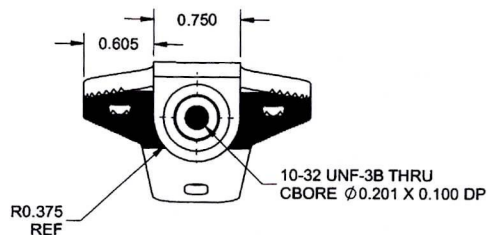
D3674-041 ROLLER BRACKET ASSEMBLY

RELEASED
 2016-07-26
 ECU-531

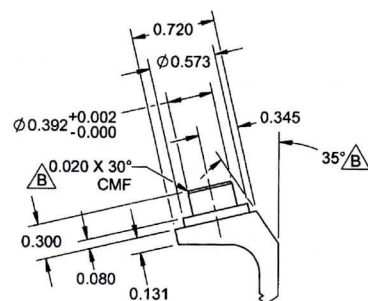
B	GENERAL UPDATE TO CURRENT STANDARDS. ADD -3/8"-7/8"-043/-044/-045, FOR BELL COMPOSITE DOOR. B5-2 DIM 0.162 WAS 0.130. B7-2 35° WAS 30°. SHT 2 UPDATE NOTE 6. SEE PAR 16-501.		AJS	16.06.01
A	NEW ISSUE		AJS	08.03.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	MB	DRAWING NO.		REV. B
MFG. APPR.	RQ	D3674		SHEET 1 OF 8
APPROVED	WM	TITLE		SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY		NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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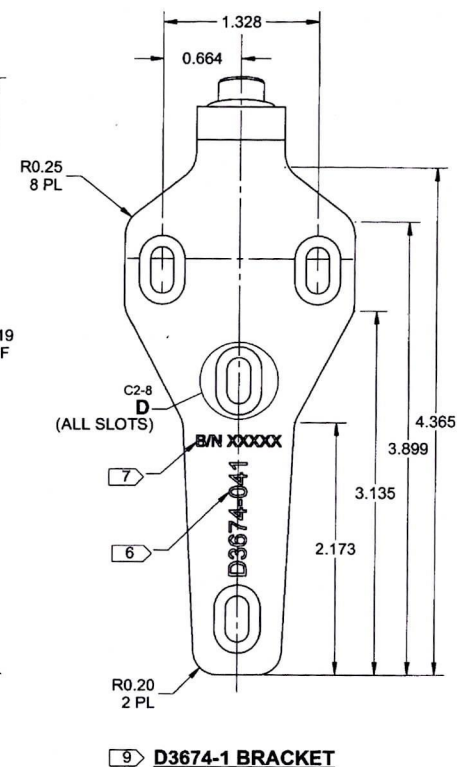
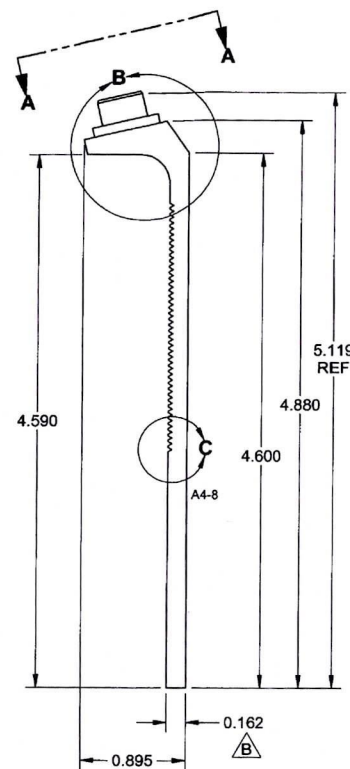
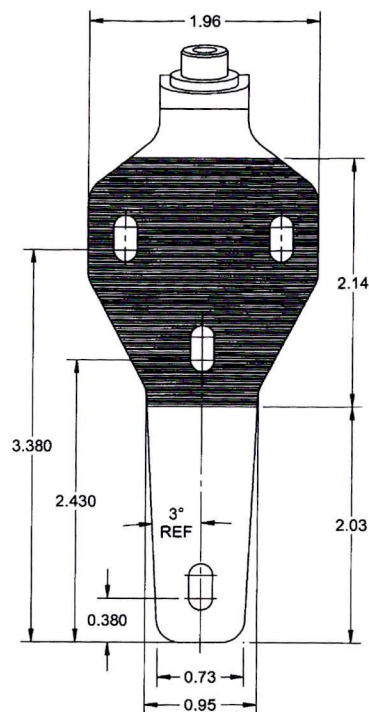
7/29/16
 SH
 149708



VIEW A-A



DETAIL B



NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-041" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.27 lbs
- 9) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.
- 10) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-1RevB.STP/SLDPRT"

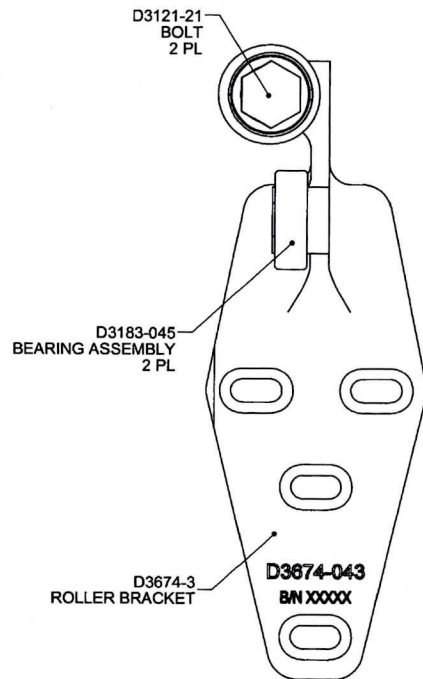
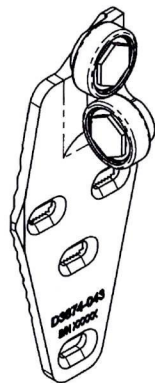
RELEASED
2016-07-26

APPROVED

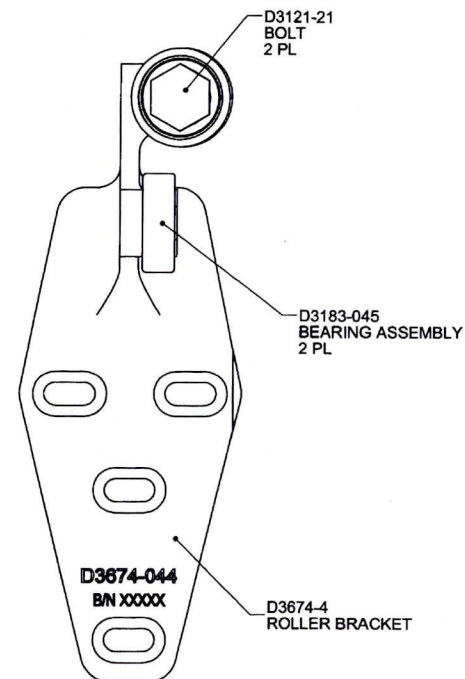
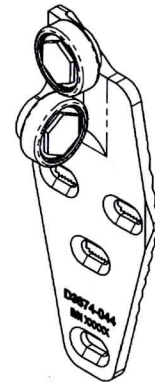
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 2 of 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	4 ROLLER BRACKET ASSEMBLY	NTS
DATE	16.06.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3674-043	ROLLER BRACKET ASSEMBLY
1	1	D3674-3	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3674-044	ROLLER BRACKET ASSEMBLY
1	1	D3674-4	ROLLER BRACKET
2	2	D3183-045	BEARING ASSEMBLY
3	2	D3121-21	BOLT



D3674-043 ROLLER BRACKET ASSEMBLY



D3674-044 ROLLER BRACKET ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.37 lbs
 - 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

RELEASED
2016-07-26

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	MB	DRAWING NO. D3674
MFG. APPR.	RQ	REV. B
APPROVED	WM	TITLE ROLLER BRACKET ASSEMBLY
DE APPR.	DS	SCALE NTS
DATE	16.06.01	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHEET 3 OF 8

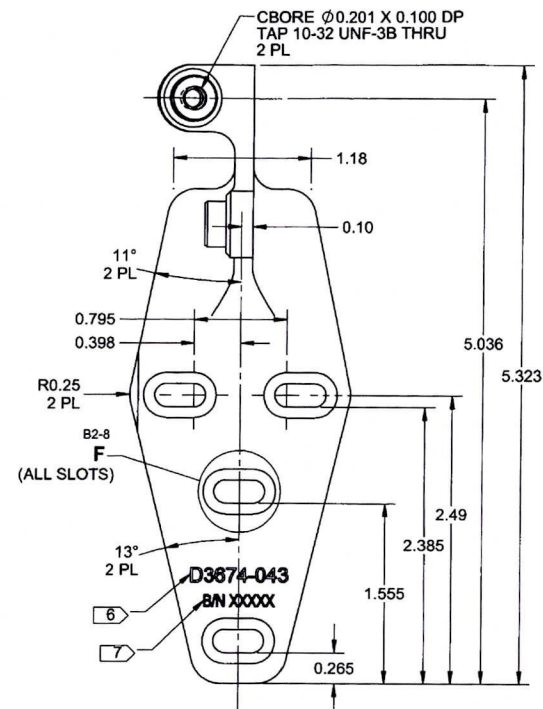
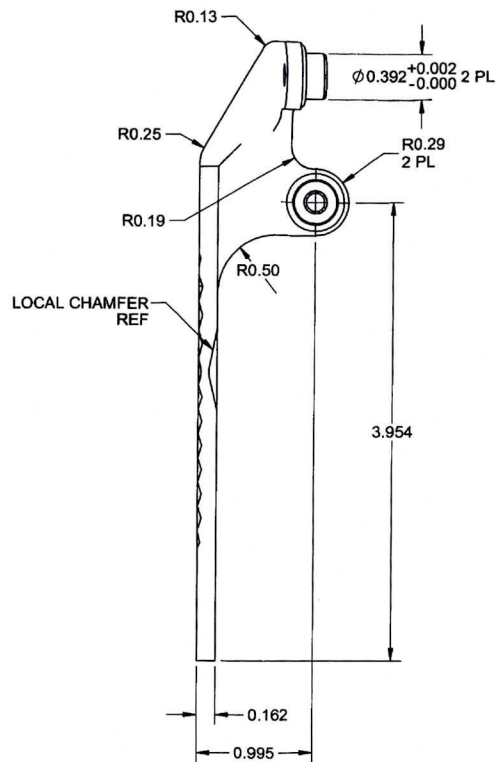
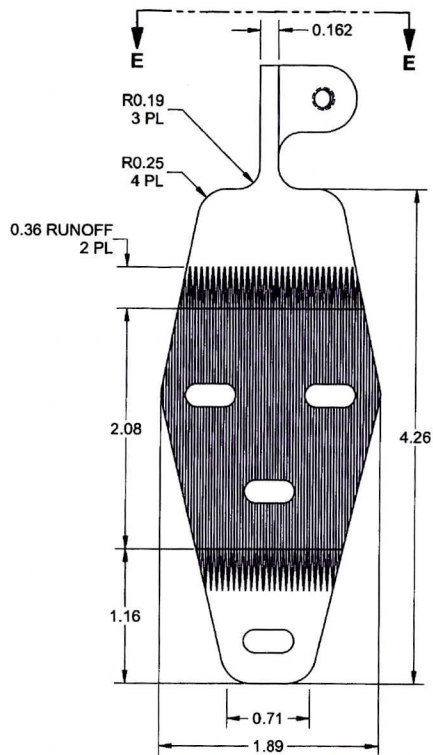
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B

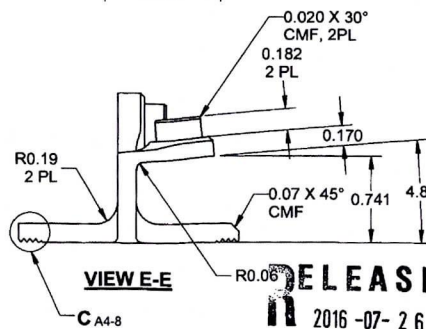
A



D3674-3 ROLLER BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-043" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.31 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-3RevB.STP/SLDPRT"



VIEW E-E

RELEASED
2016-07-26

APPROVED

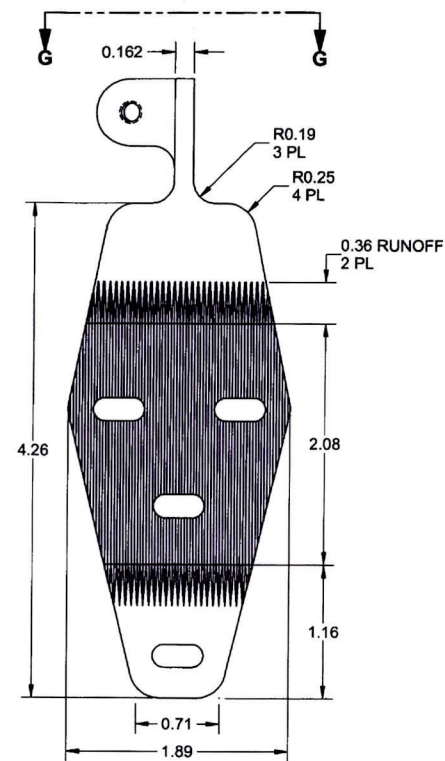
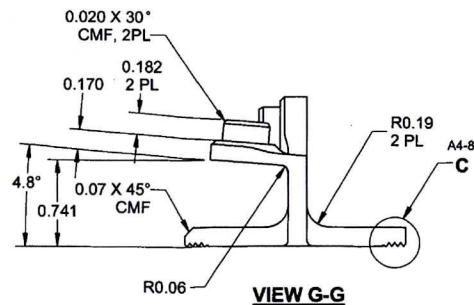
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DRAWN	AJS
CHECKED	MB
MFG. APPR.	RQ
APPROVED	WM
DE APPR.	DS
DATE	16.06.01

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3674** REV. B
SHEET 4 OF 8
TITLE **ROLLER BRACKET ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1



1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-044" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.

7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4

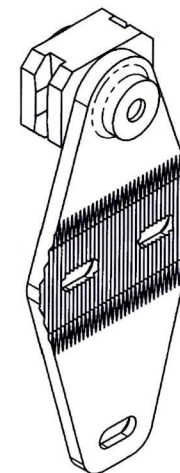
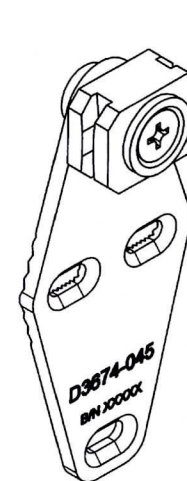
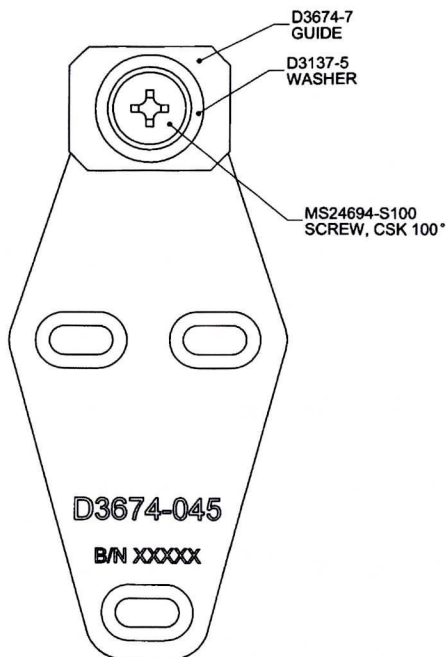
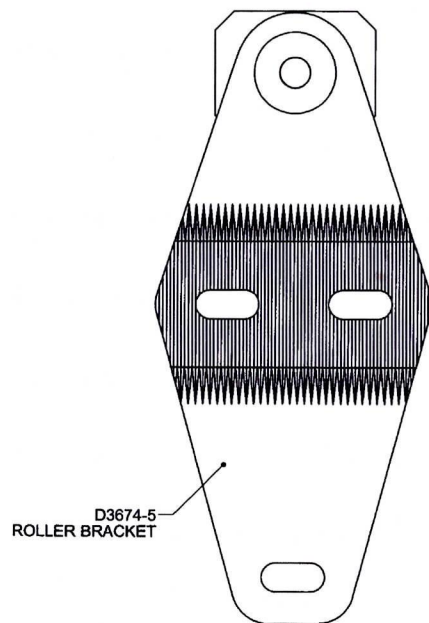
8) WEIGHT: 0.31 lbs

9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-4RevB.STP/SLDPRT"

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2016-07-26

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
DATE	16.06.01	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT A WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3674-045	ROLLER BRACKET ASSEMBLY
1	1	D3674-5	ROLLER BRACKET
2	1	D3674-7	GUIDE
3	1	D3137-5	WASHER
4	1	MS24694-S100	SCREW, CSK 100*



D3674-045 ROLLER BRACKET ASSEMBLY

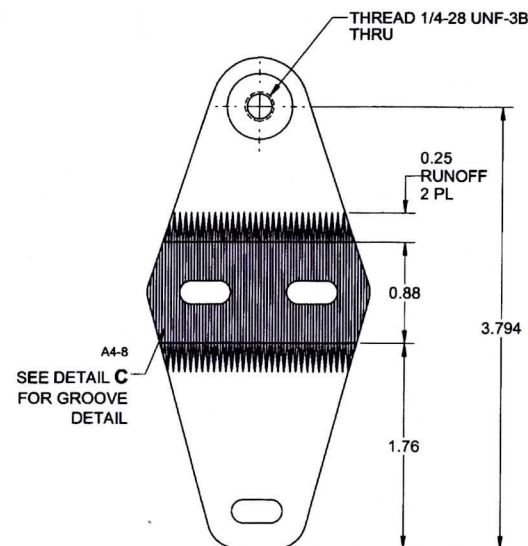
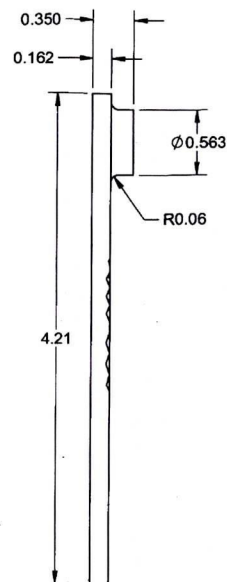
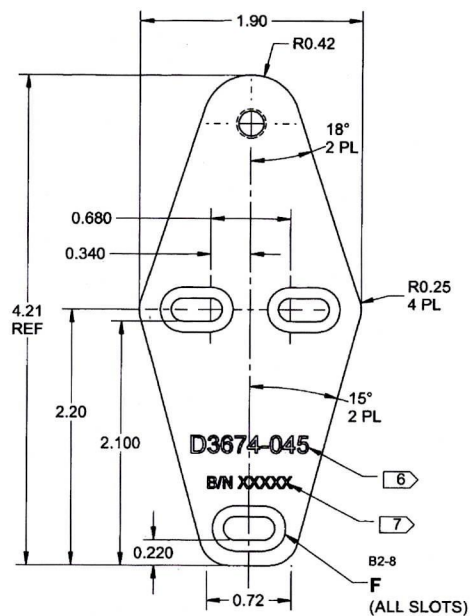
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TORQUE MS24694-S100 BOLT 50-70 in lbs (5.6-7.9 Nm)

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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D3674-5 ROLLER BRACKET

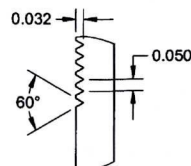
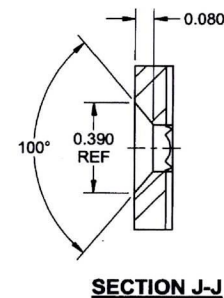
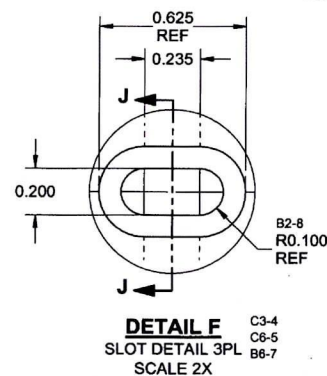
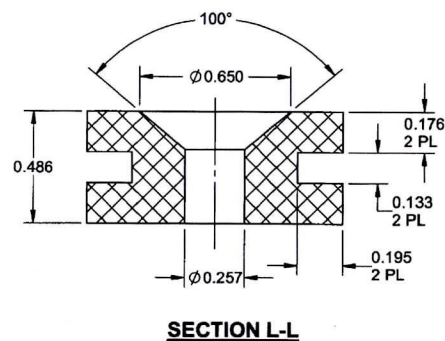
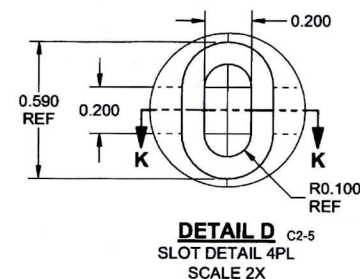
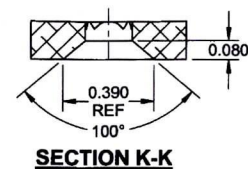
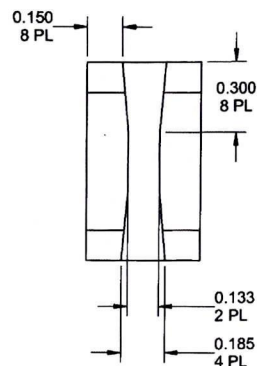
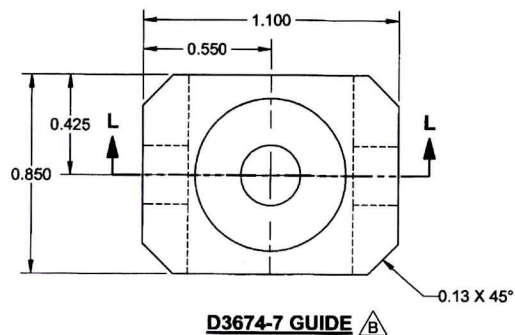
NOTES:

- 1) MATERIAL: 17-4 PH. STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
REF. DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-045" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: SCRIBE B/N PER QSI 044 6.4
- 8) WEIGHT: 0.24 lbs
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3674-5RevB.STP/SLDPRT"

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 7 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY	NTS
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- NOTES:**
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.02 lbs

DETAIL C C3-2
A5-4
A3-5
C3-7

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2016-07-26

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	RQ	D3674	SHEET 8 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ROLLER BRACKET ASSEMBLY NTS	
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1149768
D3674-045

DART AEROSPACE LTD		Work Order:
Description: <u>Roller Bracket Assembly</u>		Part Number:
Inspection Dwg: <u>D3674</u>	Rev: <u>B</u>	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.21	±.030	4.210	—		Vern HI-06	
2.20	±.030	2.200	—		"	
2.10	±.030	2.100	—		"	
.220	±.010	.220	—		"	
.72	±.030	.720	—		"	
15°	±1/2°	15°	—		C-Square	
R.25	±.030	R.250	—		R-6	
18°	±1/2°	18°	—		C-Square	
R.42	±.030	R.415	—		R-6	
1.90	±.030	1.900	—		Vern HI-06	
.350	±.010	.351	—		"	
.162	±.010	.163	—		"	
R.06	±.030	R.060	—		R-6	
Ø.563	±.010	Ø.564	—		Vern HI-06	
1/4-28 UNF	N/A	1/4-28	—		"	
3.794	±.010	3.688	—		"	
1.76	±.030	1.760	—		"	
.88	±.030	.880	—		"	
.25	±.030	.250	—		"	
.032	±.010	.032	—		"	
60°	±1/2°	60°	—		"	
.050	±.010	.050	—		"	
.200	±.010	.200	—		"	
.235	±.010	.238	—		"	
100°	±1/2°	100°	—		"	
.390	±.010	.392	—		"	
.080	±.010	.084	—		"	

Measured by: <u>DAS</u> <u>14</u> <u>9-89</u>	Checked by: <u>DAS</u> <u>33</u> <u>9-89</u>	QC Inspector:
Date: <u>16/08/02</u>	Date: <u>16/08/02</u>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	